

Date: Wednesday, 27/08/2008 3:15:41 PM
User: Julie Lecocq

Process Sheet

SPLIT-1

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 41649 -1
Estimate Number : 12577
P.O. Number :
This Issue : 27/08/2008 S.O. No. :
Prsht Rev. : NC
First Issue : 27/08/2008 Type : LARGE FAB ASSY
Previous Run : 41246

Drawing Name : STEP WELDMENT
Part Number : D3562042
Drawing Number : D3562 REV E
Project Number : N/A
Drawing Revision : E
Material :
Due Date : 08/09/2008

Written By :
Checked & Approved By : JUL 08.8.26
Comment : Est Rev:A New Issue 06-11-09 JLM
Est rev B ECN 987 07.10.09 EC verified by: DD
Est Rev:C ECN1048 07-12-18 DD verified by: EC
Est Rev:D 08-07-28 add chemical conversion coat DD
verified by:EC

Qty: 4 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Step Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
Qty Part # Description Batch:
1 D2622-120C Extrusion 40937

Check Material for any Dents or Defects

Sad 08/08/27

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion as per Dwg D3562

2-Deburr and bevel ends for welding

SAD 08/08/27

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sad 08/08/08

4.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

m/b 08/08/20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 27/08/2008 3:15:42 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 41649

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



42



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-28

4x

6.0

D3560042

Arm Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

ARM WELDMENT

Batch: B35296

SP 08.11.06 2x

7.0

D3560044

Arm Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

ARM WELDMENT

Batch: B41288

SP 08.11.06 (2x)

8.0

MS20600AD4W5

Blind Rivet



Comment: Qty.: 32.0000 Each(s)/Unit Total : 128.0000 Each(s)

Blind Rivet

batch: M108990

SAD 08/11/06 (2x)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Drill Rivet holes as per dwg D3562. Touch up alodine

2- Rivet legs using Magnabond as per dwg D3562.

*****Ensure to wipe off any excess magnabond *****

SP 08.11.06 (2x)

A/R Magnabond 6398 Batch: M106695

SAD 08/11/06

(2x)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/11/06 (2x)

11.0

D2734

Step End Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

2 D2734

Description Batch

End Cap B39179

SP 08.11.10 (4x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3562-042 PAR #: N/A Fault Category: _____ NCR: Yes ☒ No ☐ DQA: JA Date: 08.11.13
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: _____ Date: _____

NCR: <u>41649</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/11/06	9.0	had to replace 10 rivets because they where not correctly put in the step R.C. screws were breaking	<u>08/11/06</u>	Scrap and replace all (+10) M 106695	<u>SAD</u> 08/11/06	<u>08/11/06</u>	<u>08/11/06</u>	<u>08/11/06</u>
		under the screws the heads of rivets (too shallow)		* Apparently hole sizes were good, according to inspector <u>Z</u>				

NOTE: Date & initial all entries

Date: Wednesday, 27/08/2008 3:15:42 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 41649

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld end caps as per Dwg D3562 & QSI 004. Inspect for foreign objects as per QSI 024.
A/R Aluminum Rod *M104855*

SP 08.11.10 (2)

2-Grind end cap welds flush as per Dwg D3562

SPD 08/11.10 (2)

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Mo 08/11/11 (2)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Jo 08.11.11 (2)

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FX 08/11/12 (2)

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M109152

M-L 08/11/13 (2x)

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch: *M109219*

FX 08/11/13 (2)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

EP 08/11/13 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 27/08/2008 3:15:42 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 41649

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

GA

40998

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/13 *GA*

Job Completion



u 08.11.13

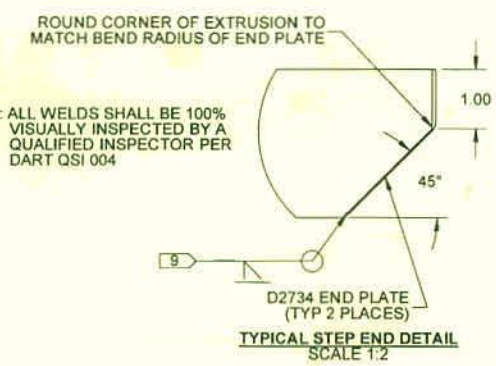
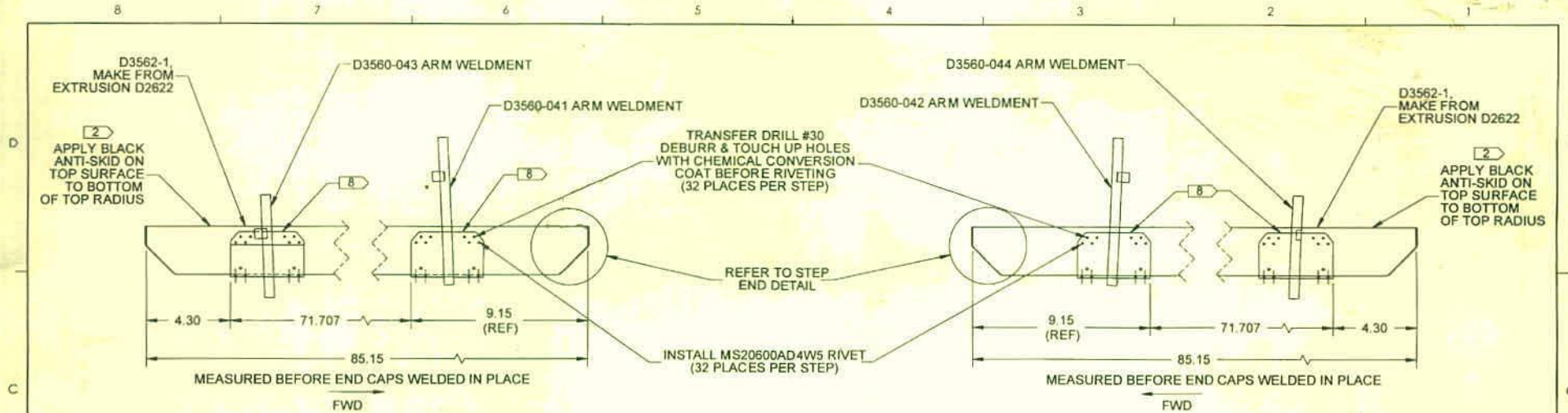
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3562-041 LH STEP ASSEMBLY

D3562-042 RH STEP ASSEMBLY

NOTES:
1) MATERIAL: N/A
2) FINISH:

- i) CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY
- ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 8.79 lbs
- 8) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 9) WELDING: PER DART QSI 094

QTY	QTY	P/N	DESCRIPTION
-041	-042		
X		D3562-041	LH STEP ASSEMBLY
	X	D3562-042	RH STEP ASSEMBLY
1		D3560-041	ARM WELDMENT
1	1	D3560-042	ARM WELDMENT
1		D3560-043	ARM WELDMENT
	1	D3560-044	ARM WELDMENT
32	32	MS20600AD4W5	RIVET
2	2	D2734	END PLATE

E	ADD QTY (2) TO D2734 END PLATE ON D3562-042	PH	08.01.11
D	REMOVE D2808 SPACER NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	NOW MAGNOBOND, ADD D2808, REMOVE 4 RIVETS	CP	07.06.19
B	ARMS NOW RIVETED TO STEP	CP	07.01.15
A	NEW ISSUE	CP	06.09.26
REV.	DESCRIPTION	BY	DATE
DESIGN	gp		
DRAWN	sf		
CHECKED	LE		
MFG. APPR.			
APPROVED			
DE APPR			
DATE	08.01.11		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3562** REV. E
TITLE **STEP ASSEMBLY** SCALE 1:5

COPYRIGHT © 2008 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

NO WORK ORDER
 SHIP COPY
 RETURN TO
 ENGINEERING
 CONTROLLED COPY
 FOR AMENDMENT
 WITHOUT NOTICE

